

Work Order ID 70561

Monday, June 13, 2011 10:06:06 AM



Page 1

Item ID: D350-591-213

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*Date: *11-06-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3078	A								
DSI 9472	A								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-213 CHG003								
110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets. 3-Debur								

*8/10/13**for CL 11-7-13**PL 11.06.22**4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D350-591-213	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli-Access-Step, Short LH				Stop	
Start Date:	6/10/2011	Start Qty:	4.00			
Required Date:	6/22/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
130 Large Fab Large Fab	Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod 114703 3-Grind End Plate flush 117884	0.00 0.00				4	0		
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0		

11.06.22
M/AE 11.06.29 4 0
BE 11/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sublogtz

(4)
LW

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

h/Ae 11.06.29

x4

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

SB 11/07/06

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 6/22/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- Rivet Leg Assembly as per Dwg D3078.
- 2- Bevel Aft end for welding
- 3- Inspect for foreign object as per QSI 024.
- 4- Weld Aft End Plate as per QSI 004 & Dwg D3078
- A/R Aluminum Rod M114703
- 5- Grind End Plate flush

11.07.06

11.07.06

4

Ø

4

Ø

210

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

5/16/08

40

220

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5/16/08

44

LM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date:	6/22/2011	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				11-7-8			
Hand Finishing									

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:30								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 12:50								

250	Wing Walk as per dwg QSI005 4.4 Batch 117863	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

4LH x 0 M-11/07/11

4LH x 0 B-11-7-12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

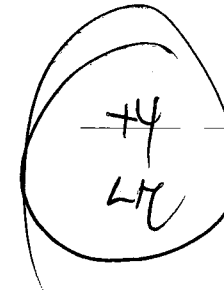


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				464	0	21	11/07/12
Quality Control									
270	Pick Kit	0.00							
Packaging	Memo	0.00							11/7/13 SL (4)
Packaging									
280	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							8 11/07/13
Quality Control									



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and leading them to success.

Page 7

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

Setup Start[illegible]

Stop

[illegible]

Author's address: Department of Psychology,
University of California, San Diego,
La Jolla, CA 92037, USA.
E-mail: jkagan@ucsd.edu

Cust Item ID:

1000

Customer:

Reference:

Run Start

[illegible]

Stop

[illegible]

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

[illegible]

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-213

Location: 30
PPP Rev: 0

300

QC21- Final Inspection - Work Order Release

0.00

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and data. This can involve research, consultation with experts, or collecting data from various sources.

3. The third step is to analyze the information and data collected. This involves identifying patterns, trends, and relationships that can help in understanding the problem.

4. The fourth step is to develop a solution or answer. This involves applying the knowledge and skills gained from the previous steps to create a response that addresses the problem.

5. The fifth step is to evaluate the solution or answer. This involves checking the results against the original problem and requirements to ensure that the solution is effective and accurate.

6. The sixth step is to communicate the solution or answer. This involves presenting the findings in a clear and concise manner, using appropriate language and format.

7. The seventh step is to reflect on the process. This involves thinking about what was learned from the experience and how it can be applied to future problems.

8. The eighth step is to seek feedback. This involves asking others for their thoughts and suggestions on the solution and the process used to develop it.

9. The ninth step is to implement the solution. This involves putting the solution into practice and monitoring its effectiveness over time.


10. The tenth step is to review the results. This involves evaluating the outcomes of the implementation and making any necessary adjustments to improve the solution.

QC

Memo

0.00

Quality Control

11/7/14 
mf 11-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, June 13, 2011 10:06:12 AM

Page 1

Work Order ID: 70561

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 6/10/2011


Required Date: 6/22/2011

Start Qty: 4.00


Required Qty: 4.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified
 by:JLM IPP Rev:E
 10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C  Step Extrusion		Manufactured	No			110	Each	35.7000	0.5	2		<u>11.06.22</u>	
--	--	--------------	----	--	--	-----	------	---------	-----	---	--	-----------------	--

Location	Loc Qty	Loc Code
HALL <u>368293</u>	6	
64409	6	
WA	29.7	
46910	2	
66970	27.7	

D3067-1  End Plate		Manufactured	No			130	Each	87.0000	1	4		<u>11.06.22</u>	
---	--	--------------	----	--	--	-----	------	---------	---	---	--	-----------------	--

Location	Loc Qty	Loc Code
WA	2	
67582	2	
WA016	85	
<u>68214</u>	85	

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

D3063-1

Manufactured No

130 Each

34.0000

1

4



Support



11.06.22

Location

Loc Qty

Loc Code

WA

20

66182

20

WA016

14

59663

14

MS20600-AD4W4

Purchased

No

180 Each

2,064.000

16

64



Rivets



11.07.06 Ae

Location

Loc Qty

Loc Code

ST321

2059

116188

59

117364

1000

117601

200

117885

800

WA018

5

116712

5

D3066-1

Manufactured

No

180 Each

101.0000

2

8



Spacer



11.07.06 Ae

Location

Loc Qty

Loc Code

WA

101

68337

20

69738

81

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

D3065-041

Manufactured No

180 Each

44.0000

1 4



Step Leg Assembly Hi



11.07.06 Ae / K

Location

Loc Qty

Loc Code

WA

44

66149

0

67503

4

69740

40

D3067-1

Manufactured No

200 Each

87.0000

1



End Plate



4

11.07.06

Location

Loc Qty

Loc Code

WA

2

67582

2

WA016

85

68214

85

AN3-35A

Purchased No

270 Each

117.0000

2



Bolt



117/138 4

Location

Loc Qty

Loc Code

ST353

117

117441

17

117619

50

117794

50

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2856-400 Manufactured No

270 f

121.6696 0.6



Abraison Strip

Location

Loc Qty

Loc Code

ST403

121

68076

121

ST409

0.6696

63735

0.6696

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A Purchased No

270 Each

274.0000 2



Bolt

Location

Loc Qty

Loc Code

ST356

100

117872

100

ST357

174

110382

1

115316

173

AN960JD416 NAS1149D0463J Purchased No

270 Each

0.0000 12



Washer

D2230-1 Manufactured No

270 Each

142.0000 2



Lug

Location

Loc Qty

Loc Code

ST476

142

67761

36

67826

6

69179

100

Monday, June 13, 2011 10:06:13 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

270

Each

2,290.000

2

8



Nut

Location

Loc Qty

Loc Code

ST300

2290

116391

9

116549

581

117441

800

117601

400

117885

500

AN4-13A

Purchased

No

270

Each

306.0000

4

16



Bolt

Location

Loc Qty

Loc Code

ST357

306

117962

306

D2732

Manufactured

No

270

f

233.3281

1

4.210526



Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

233.32811

64283

233.32811

cut qty of 4 at 3.00" as per dwg(D2732-030)

W/O:		WORK ORDER CHANGES					
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Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2230-3

Manufactured No

270 Each

34.0000

2

8



Lug



B70694

[Handwritten signature]

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

30

68246

30

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

0.0000

4

16



Washer



M117291

[Handwritten signature]

MS21042L4

Purchased

No

270

Each

5,203.000

6

24



Nut



11/7/13

Location

Loc Qty

Loc Code

ST300

5203

117441

2903

~~117601~~

800

117885

1500

24

AN4-16A

Purchased

No

270

Each

252.0000

4

16



Bolt



11/7/13

Location

Loc Qty

Loc Code

ST358

252

116400

52

117514

100

117872

100

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
02.09.20

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *7056*

11-06-13

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

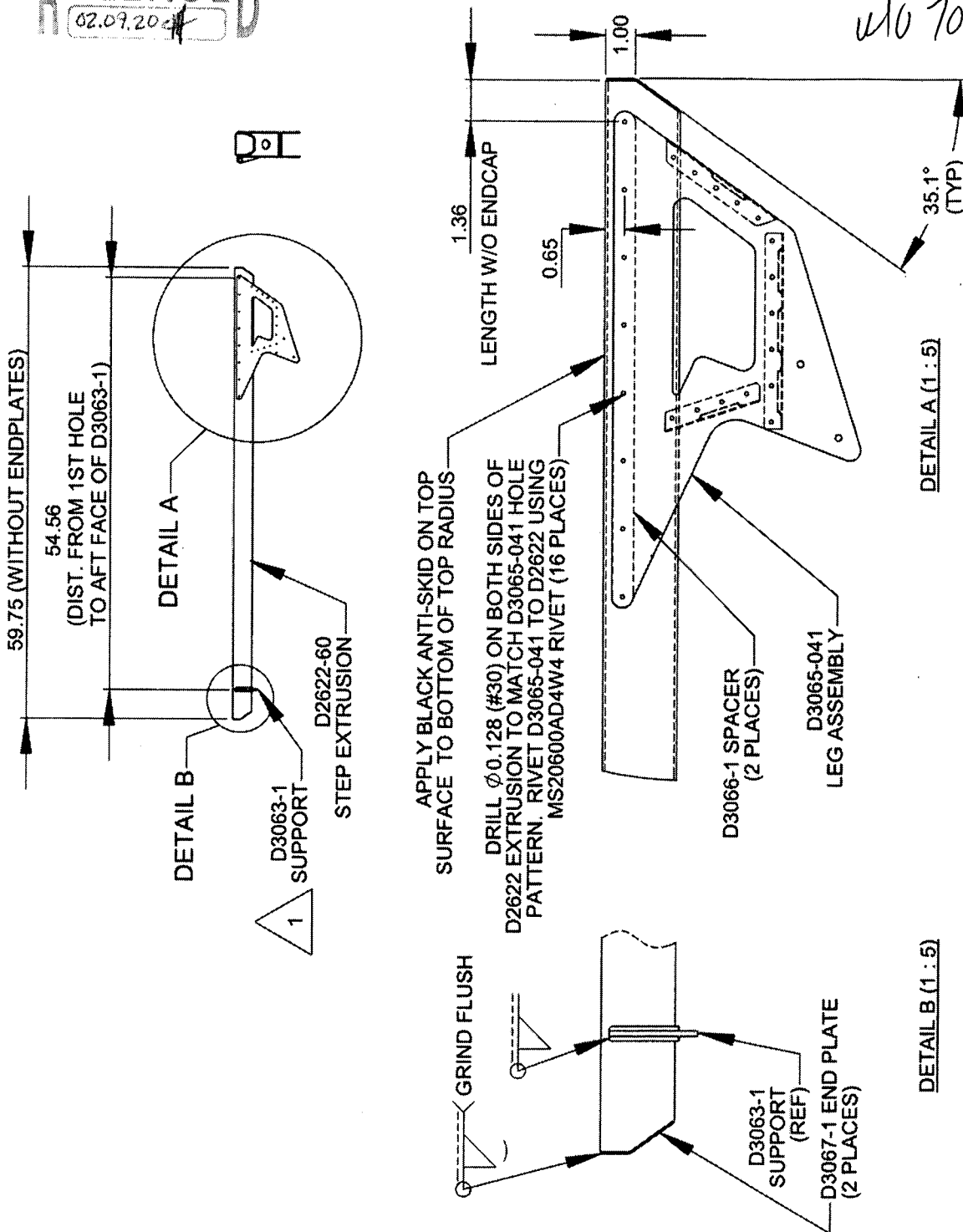
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 2 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT	SCALE 1:20

RELEASED
02.09.2011



W/O 70562

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER


REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE



For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	09.08.05
CERT. NO.:	SH92-6
ISSUE NO.:	11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. A
CHECKED	UP	DSI 9472	SHEET 1 OF 2
MFG. APPR.	N/A	TITLE	SCALE
APPROVED		BOLT ADDITION	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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